

**FIG.1**  
**(Prior Art)**

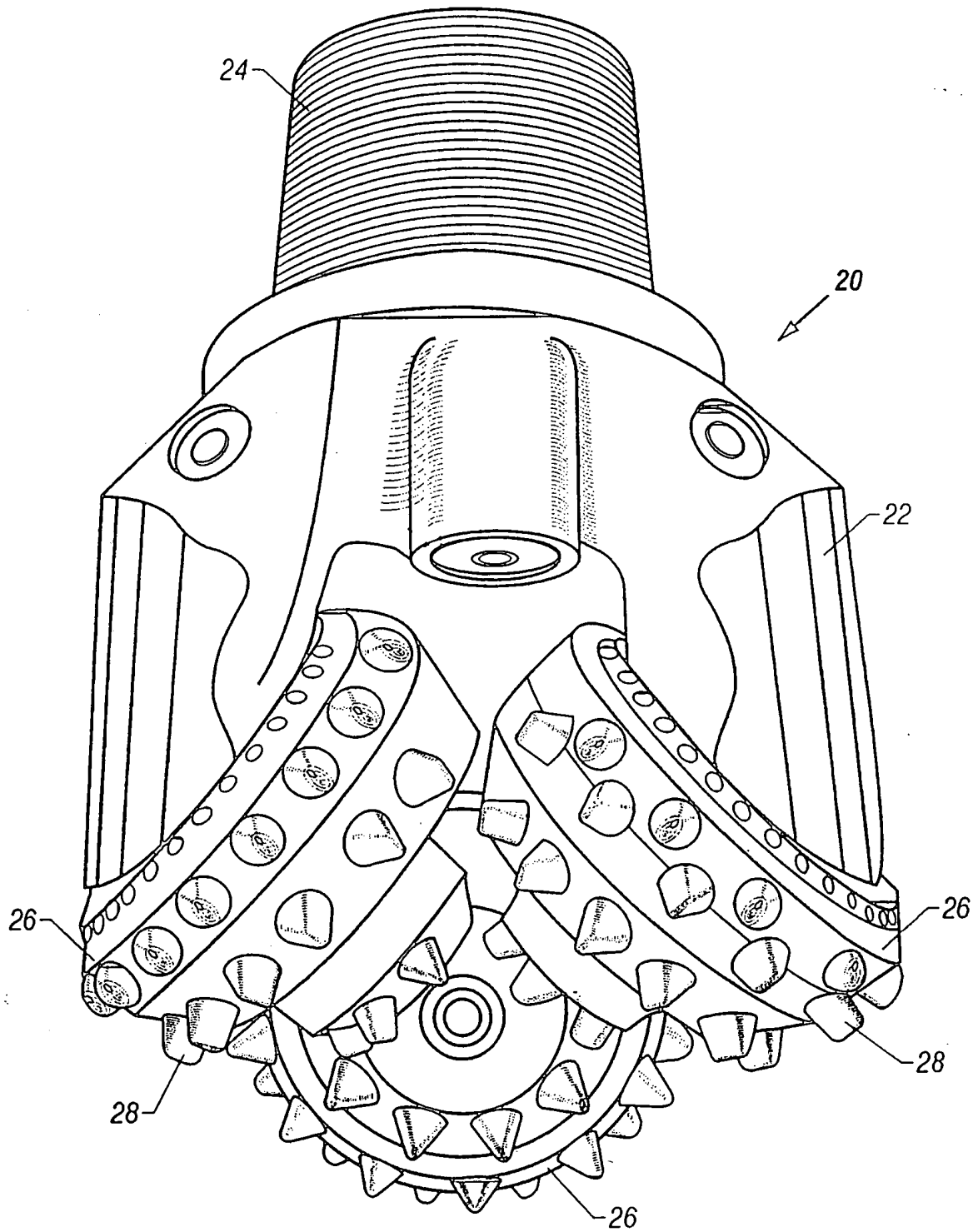
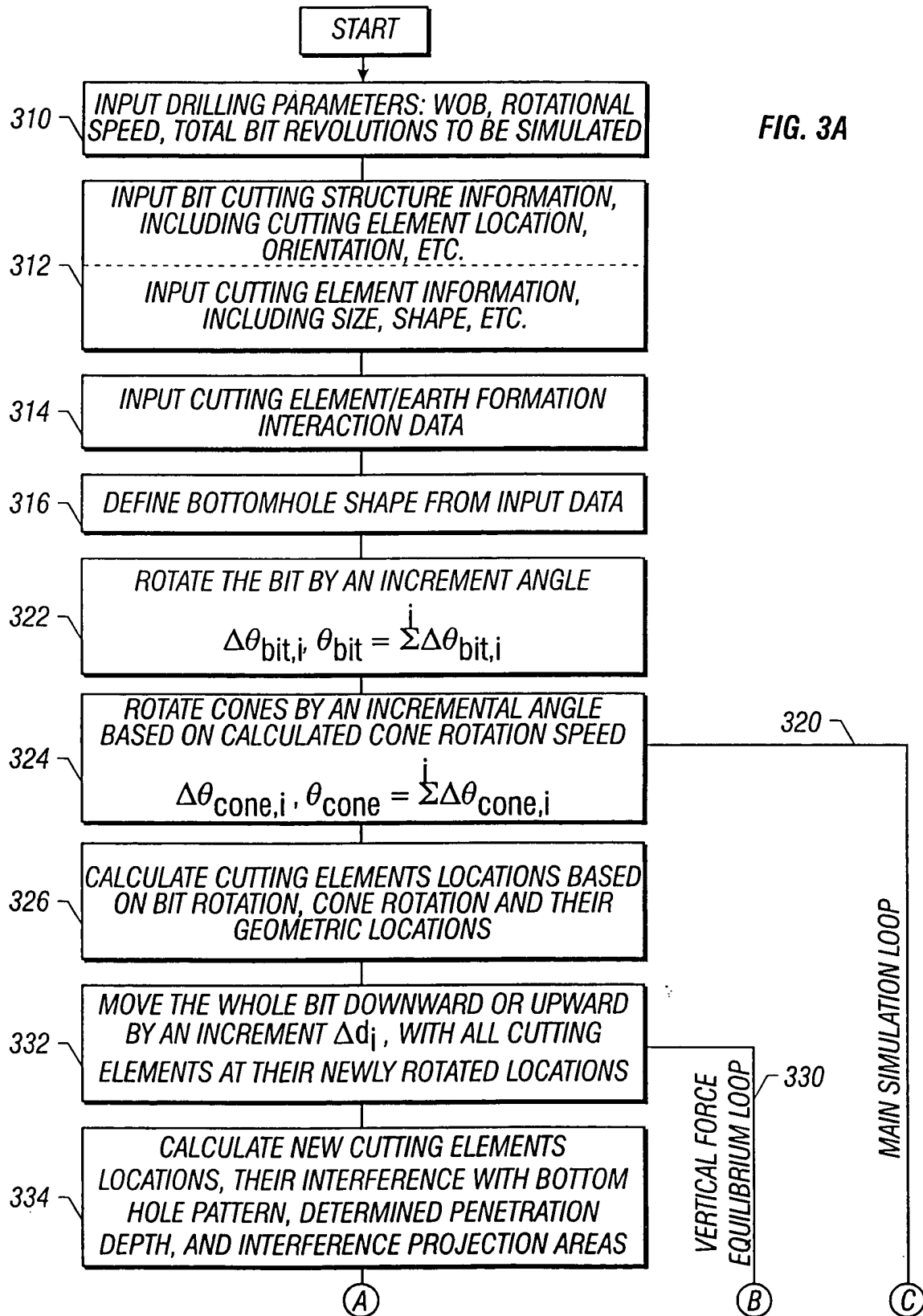


FIG.2  
(Prior Art)



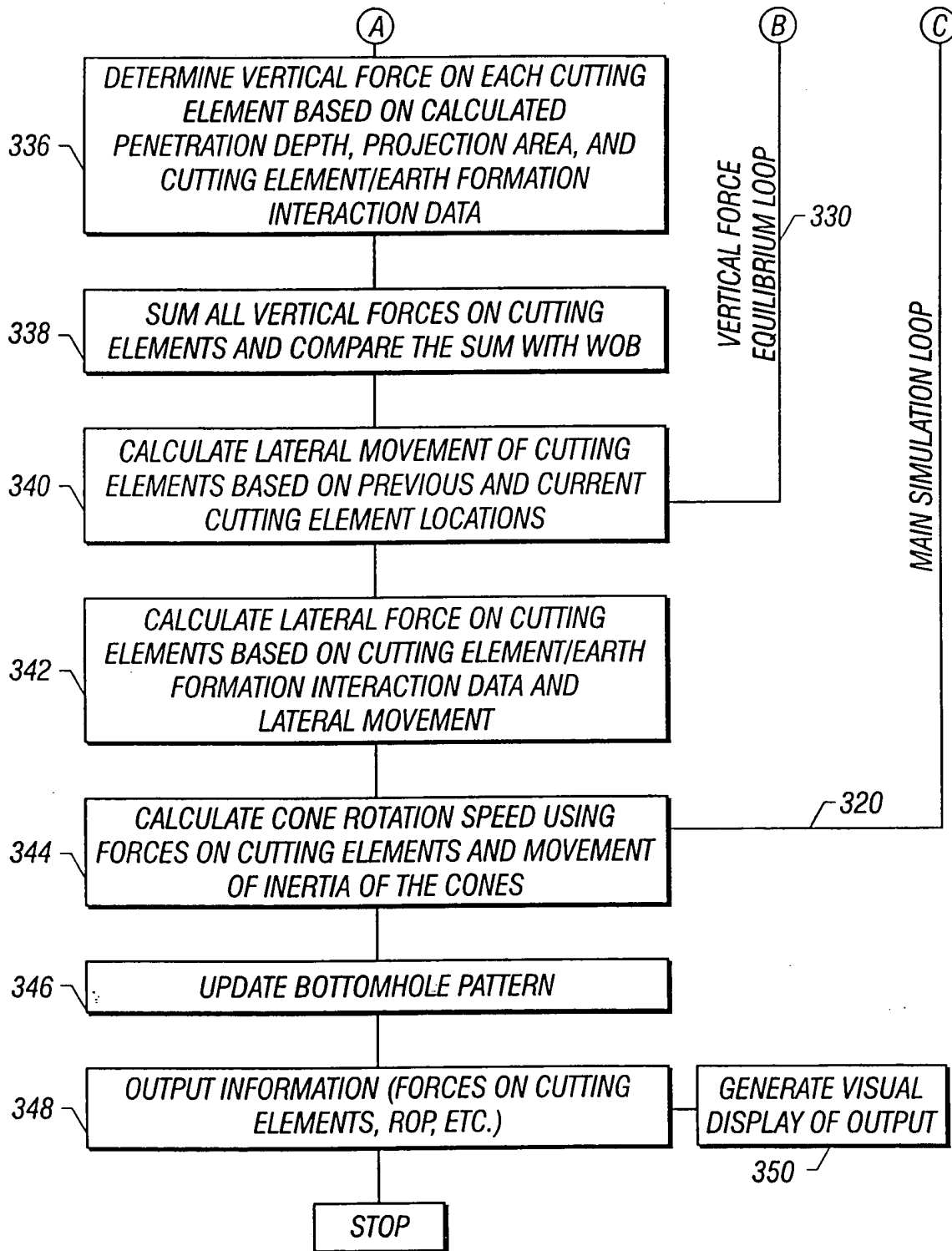


FIG. 3B

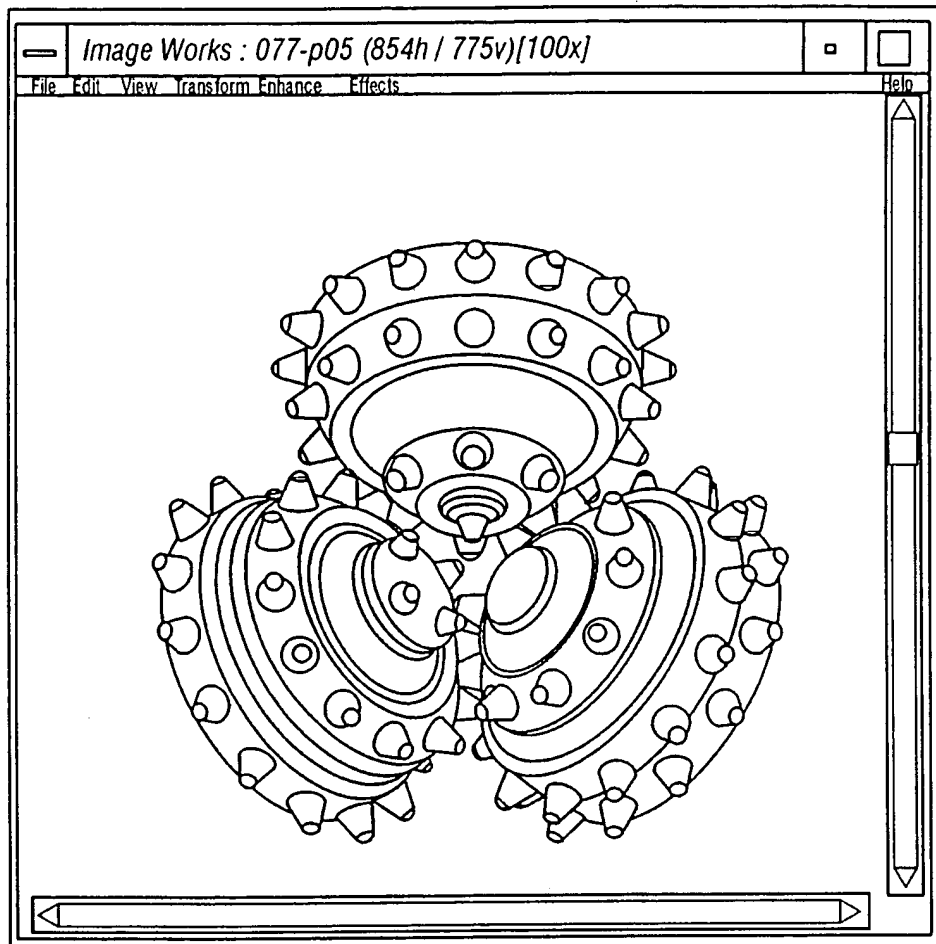


FIG. 4

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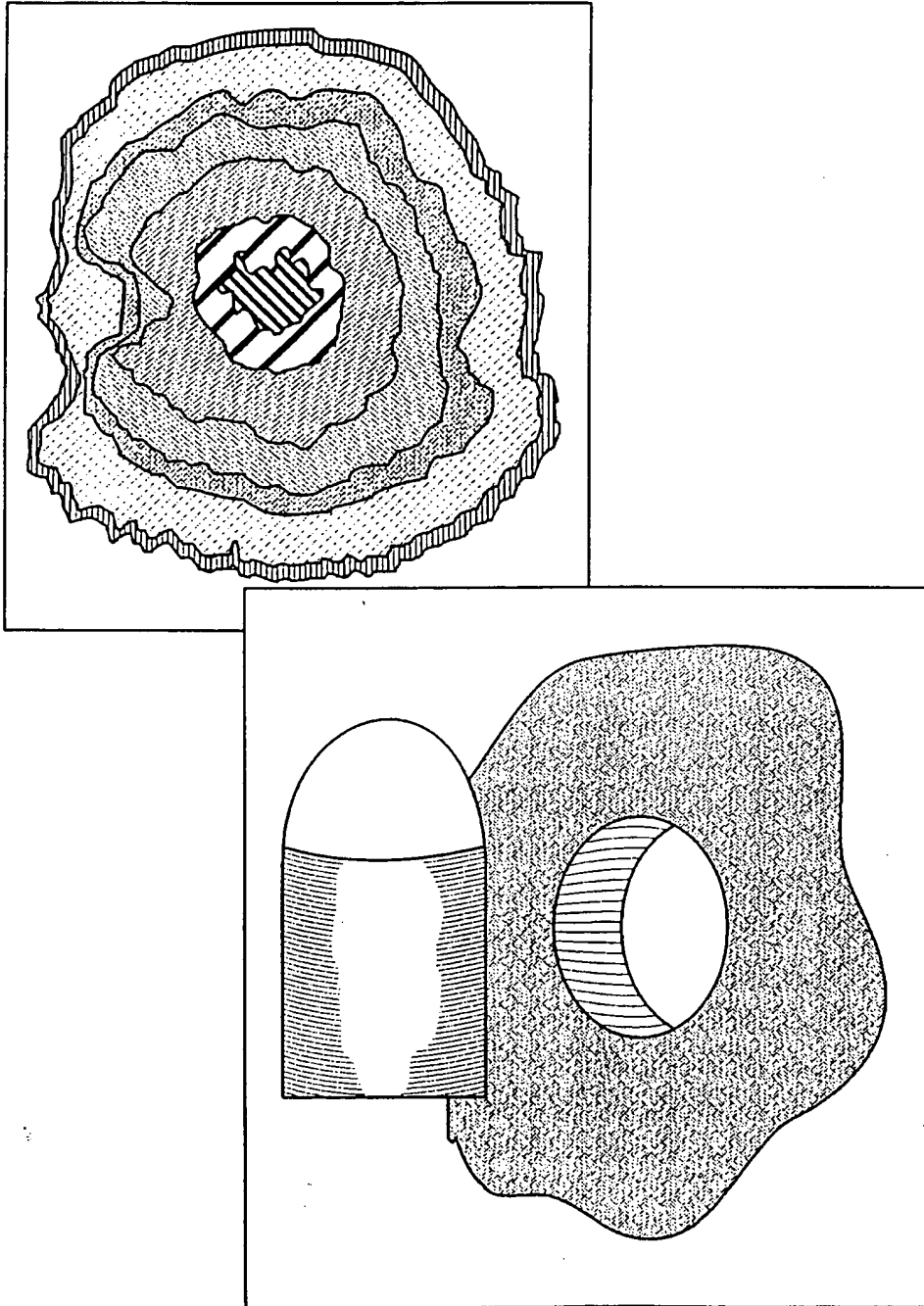
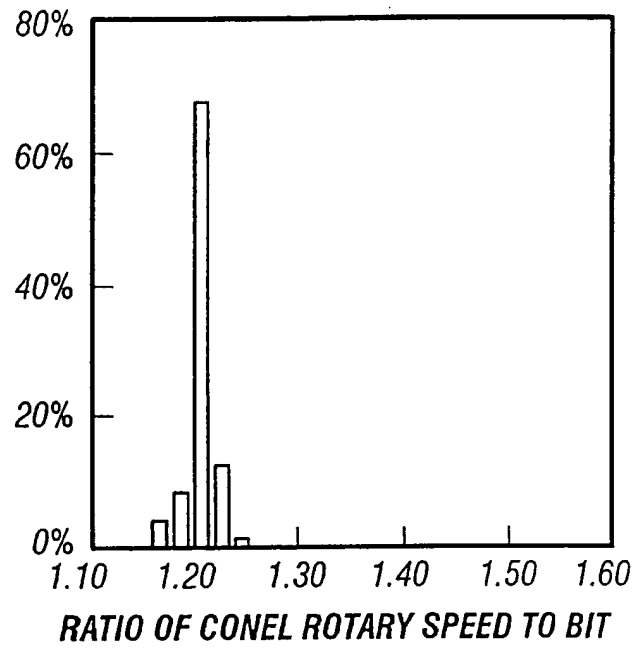
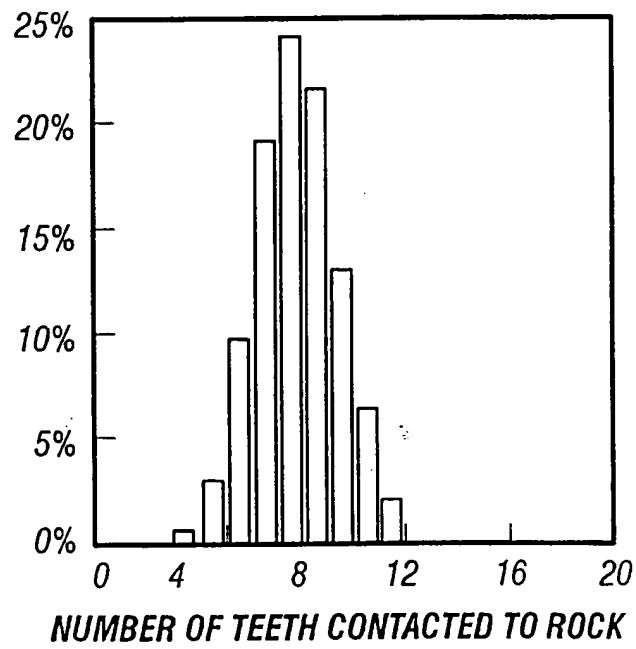


FIG. 5

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**FIG. 6A**



**FIG. 6B**

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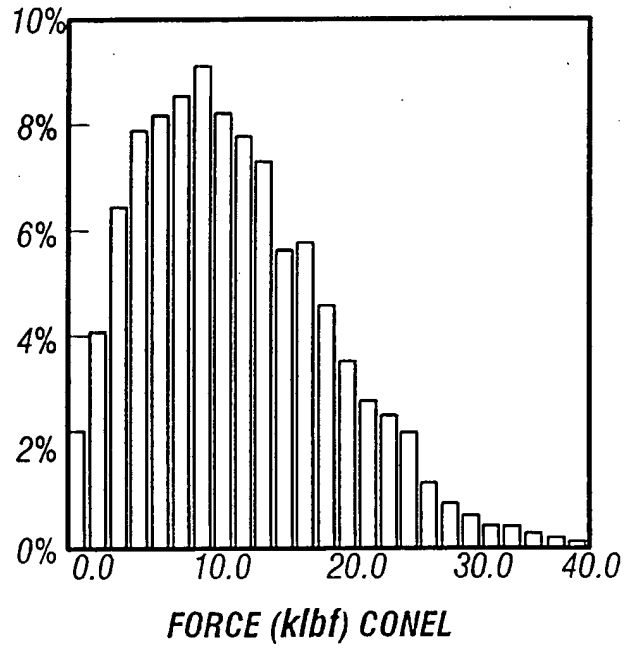
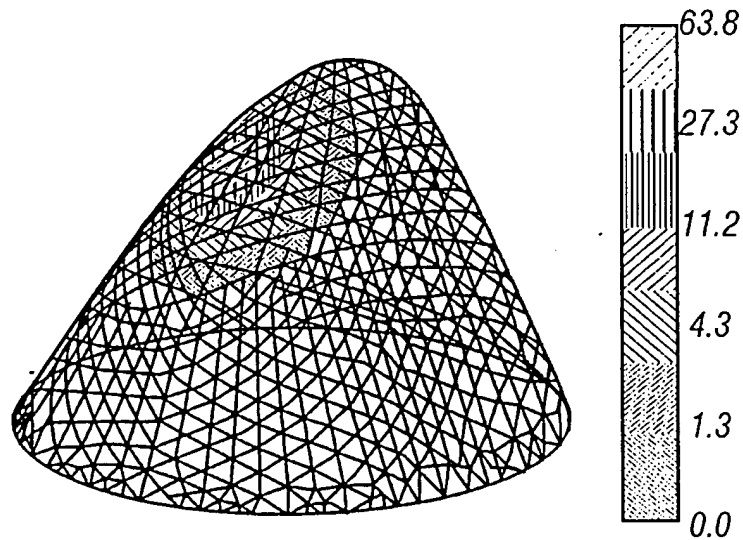


FIG. 6C



INSERT CUMULATIVE CUTTING

FIG. 6D



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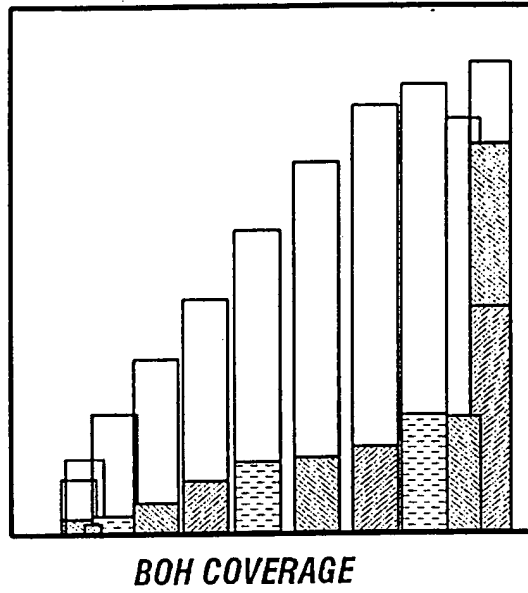


FIG. 6E

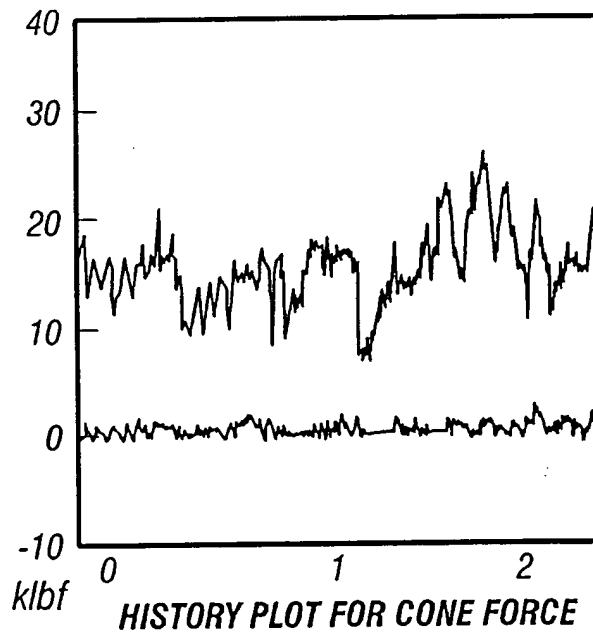


FIG. 6F

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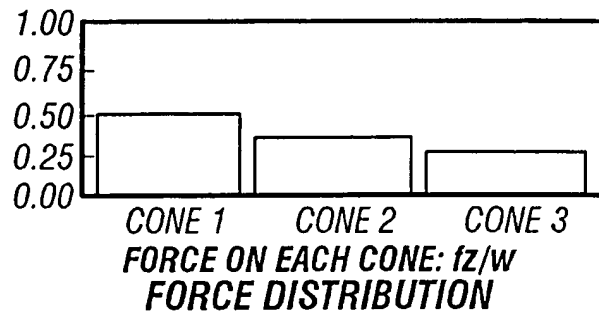
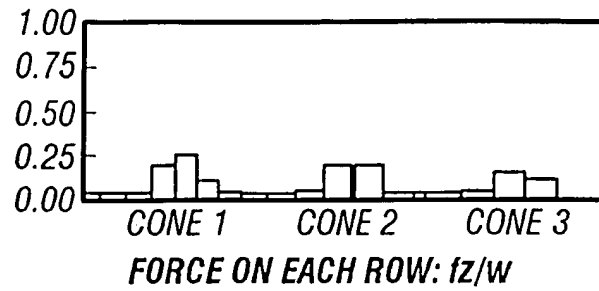
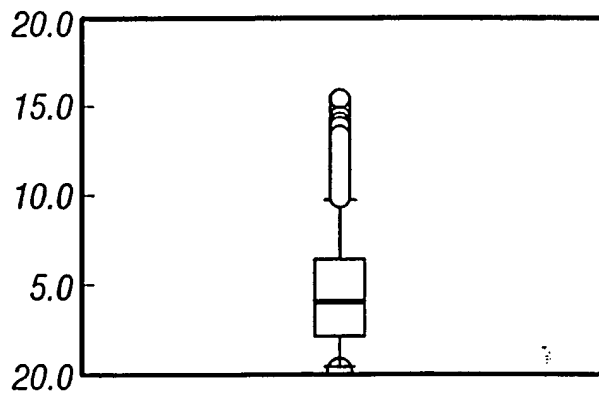


FIG. 6G



FORCE (klbf) 1C-3R  
BOX & WISKERS PLOT FOR ROW FORCE

FIG. 6H

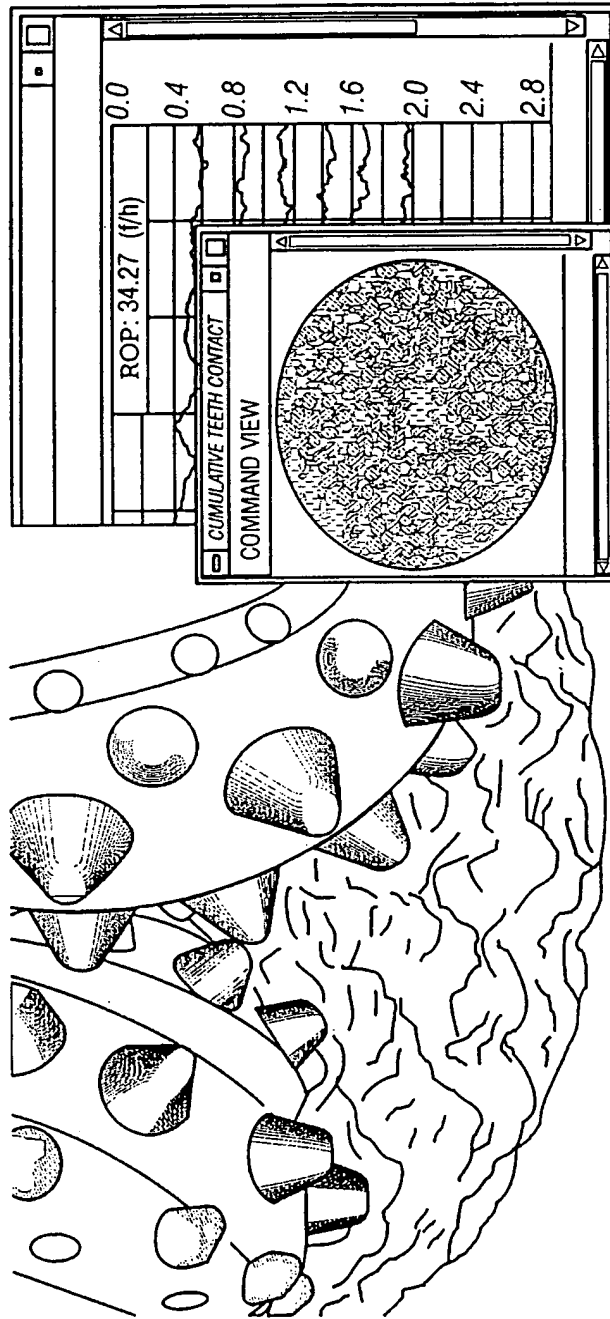


FIG. 7

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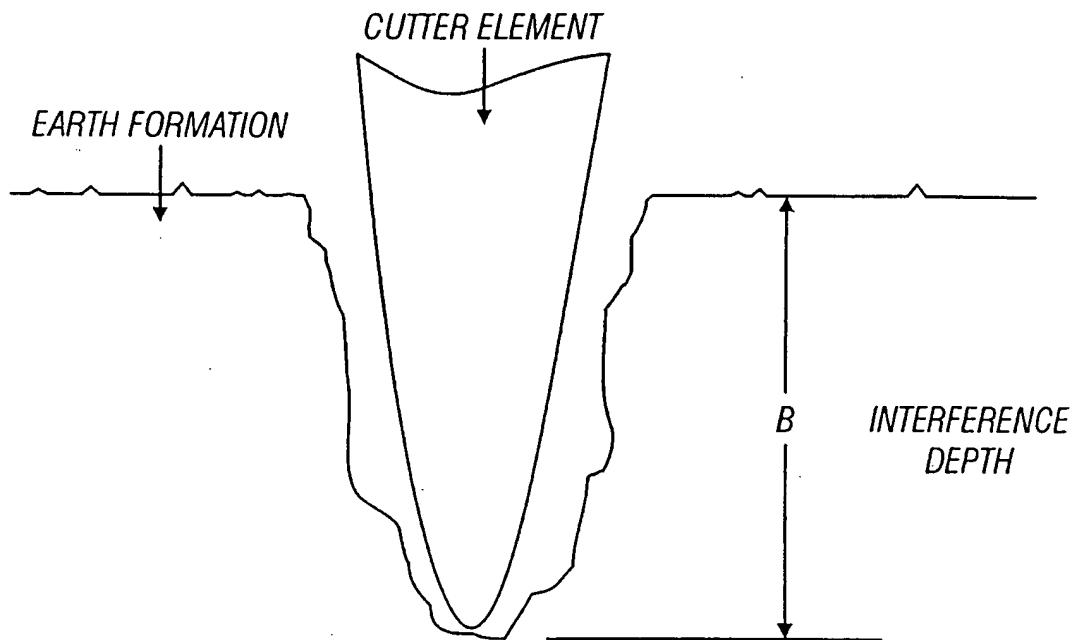


FIG. 8A

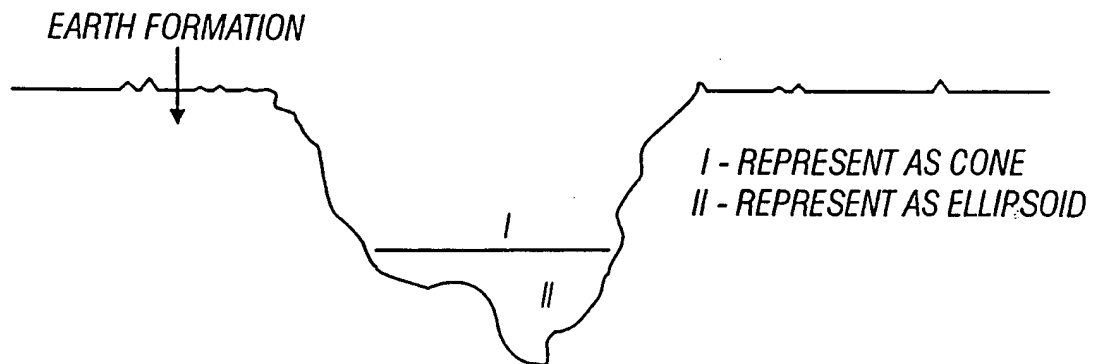


FIG. 8B

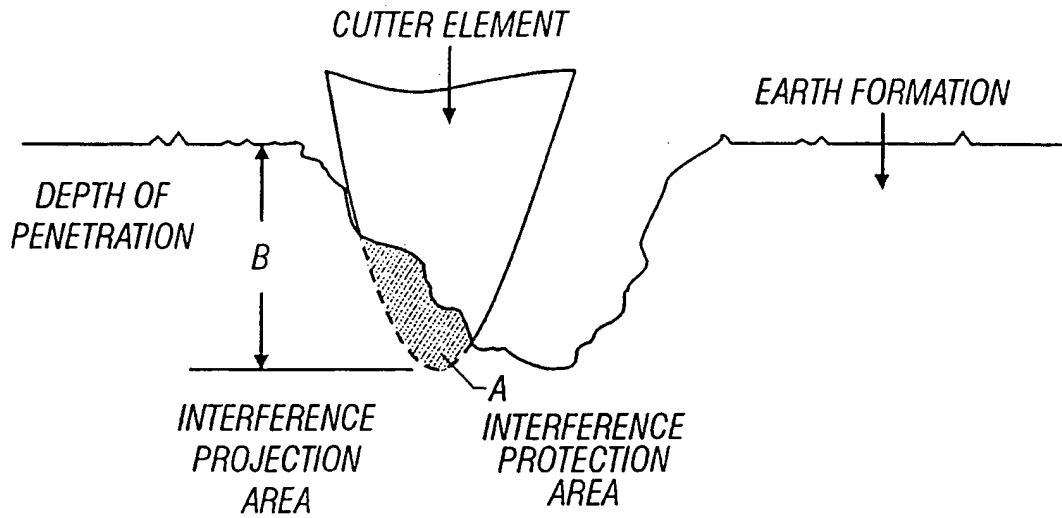


FIG. 8C

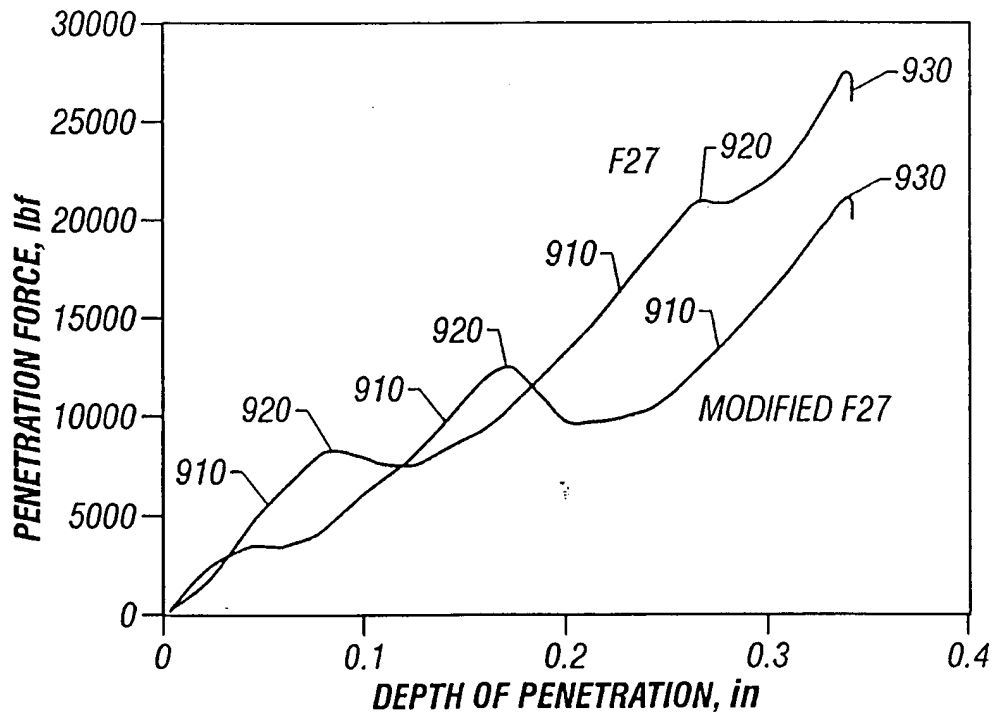
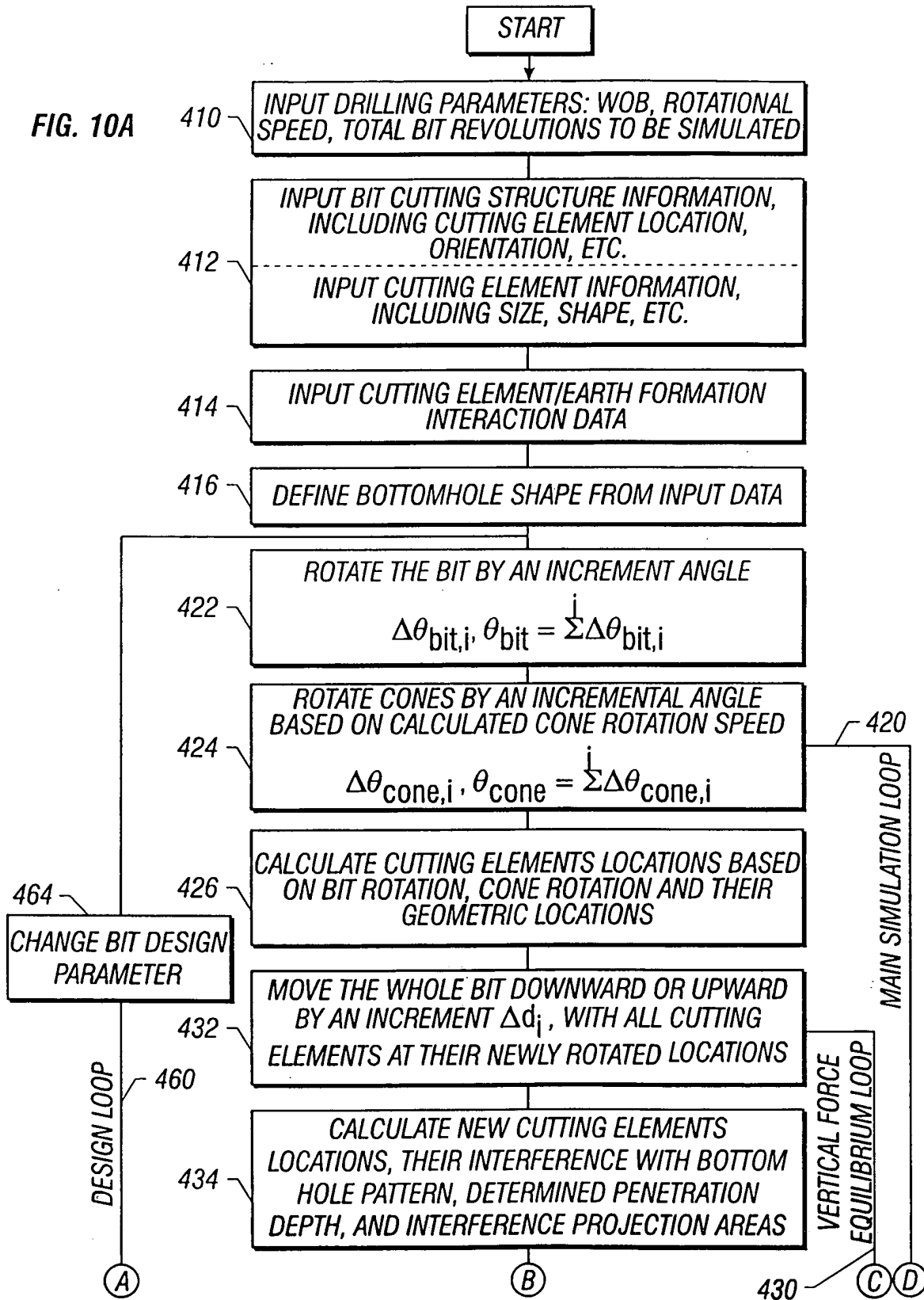


FIG. 9

FIG. 10A



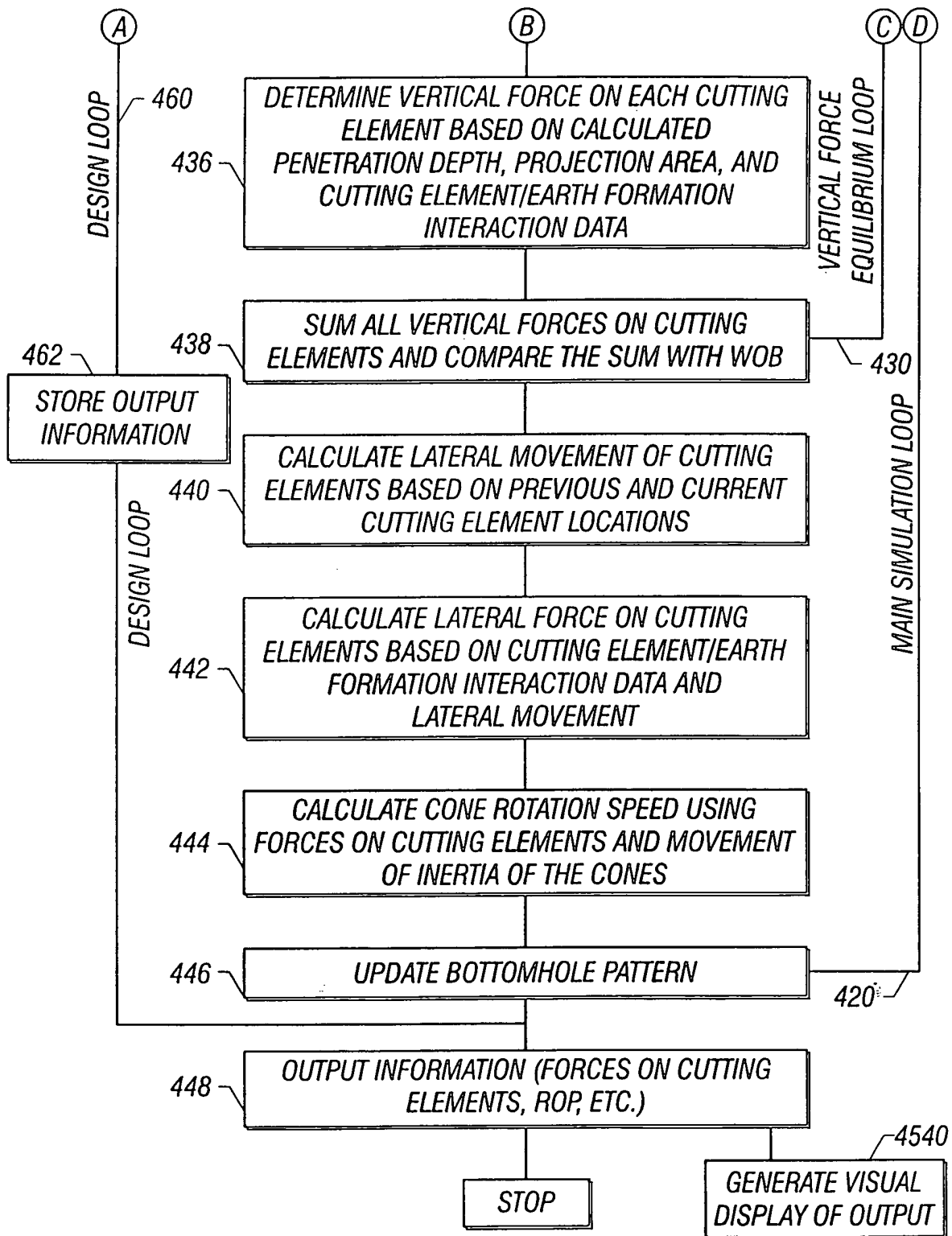
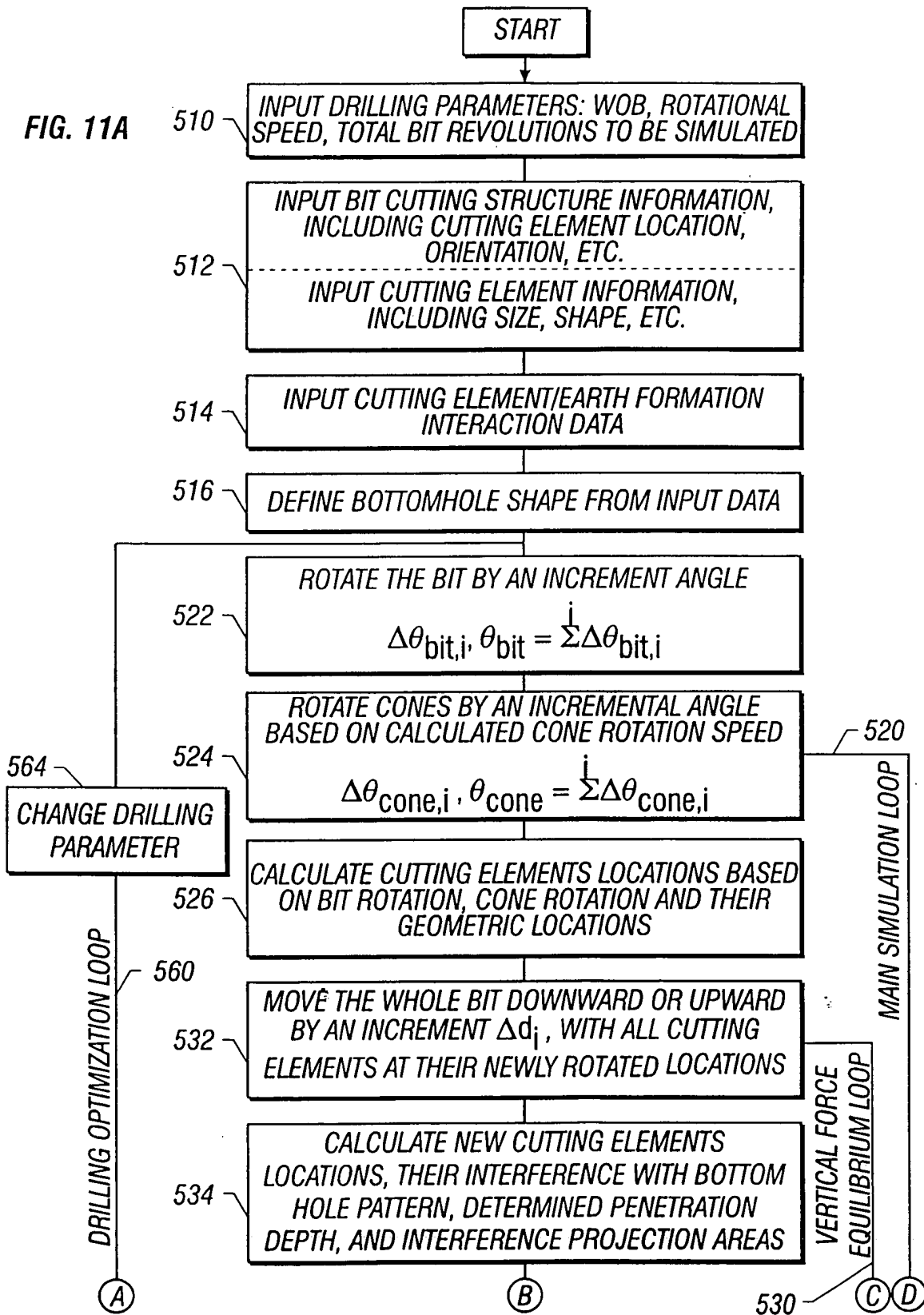


FIG. 10B

FIG. 11A





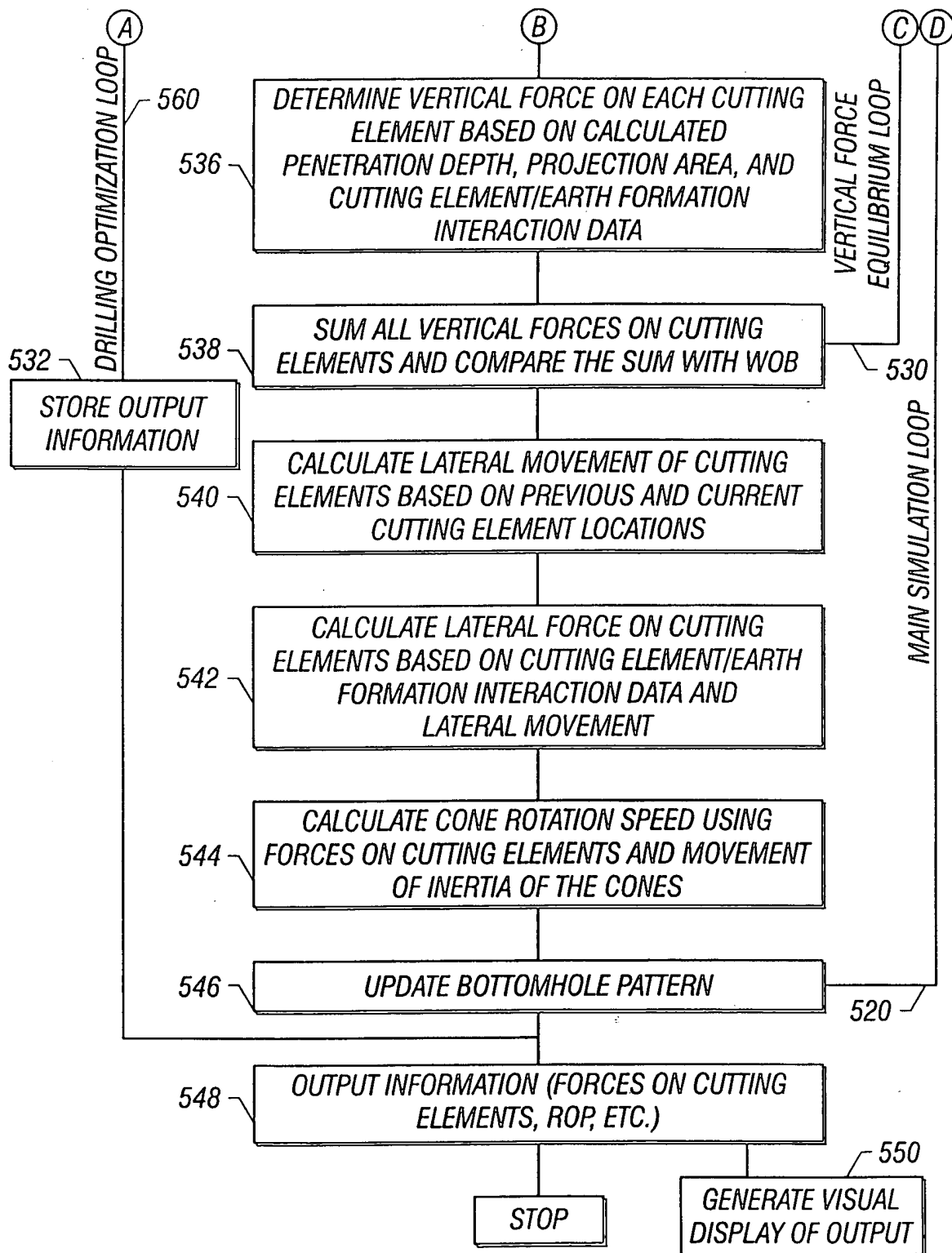


FIG. 11B